

Work Order ID 130540

Monday, March 16, 2015 7:34:04 AM

130540

Page 1

Item ID: D3270-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Base

Start Date: 3/16/2015 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/16/2015 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 1503-16 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3270

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3270Dwg Rev: B Prog Rev: B 2-Deburr
if necessary

6061.040

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(45)

DL 15/03/18

(45)

DL 15/03/18

(45)

DAS
38
9-89

MAR 19 2015

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					43	FF		MAR 24 2015
Small Fab	Memo	0.00							→ PTD
Small Fab	1-Deburr if necessary2-Form D3270-1 and drill holes using D3270-1T1 as per Dwg D3270								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								DAS
QC	Memo	0.00							38
Quality Control									9-89
									MAR 24 2015
150		0.00							
150	Identify as per dwg & Stock Location: <u>Wk 002</u>								
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****					43	EL	15-4-2	

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Page 3

Item ID: D3270-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Mounting Base

Start Date: 3/16/2015 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/16/2015 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

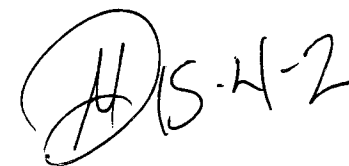
Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-02



Picklist Print

Monday, March 16, 2015 7:34:13 AM

Page 1

Work Order ID: 130540

130540

Parent Item: D3270-1

D3270-1

Parent Item Name: Mounting Base

Start Date: 3/16/2015

Required Date: 3/16/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: A New Issue 05-11-01 JLM
IPP Rev: B now water jet 08-01-24 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

110

sf

195.4306

0.0374

2

M6061T6S 040

**

DL 15/03/18

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

195.4306

m130312

6.1135

m130585

28.1501

m131352

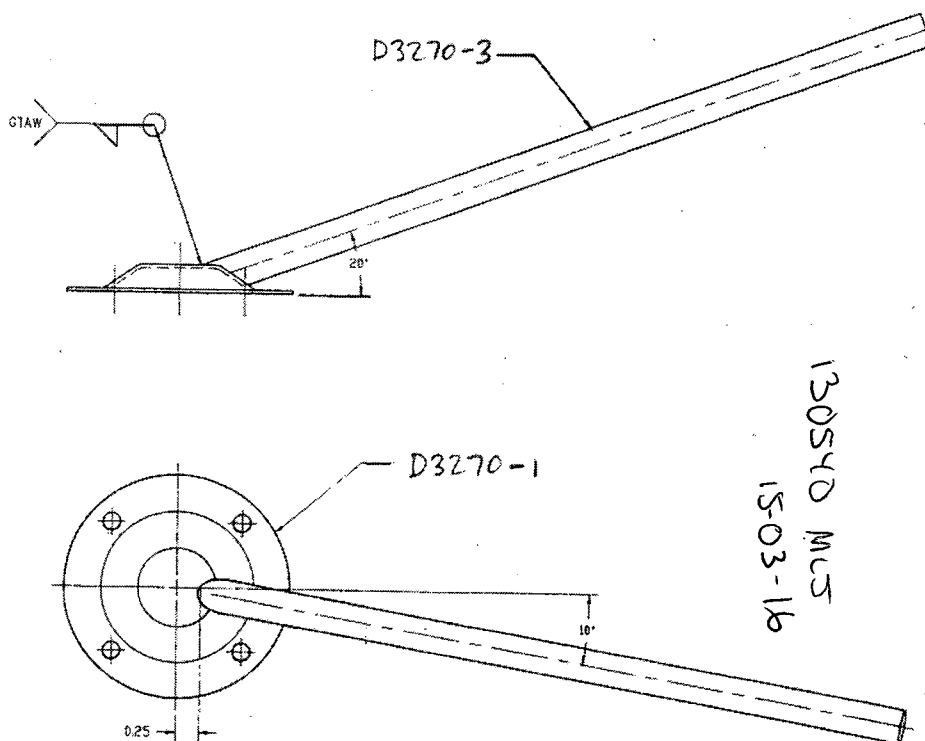
161.167

4



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	# 05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23



D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

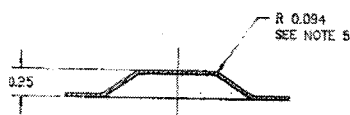
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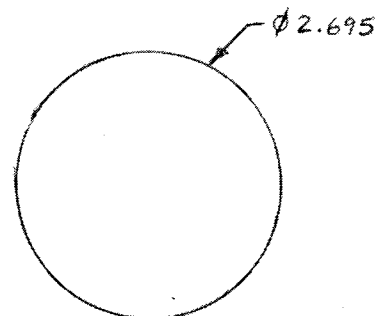
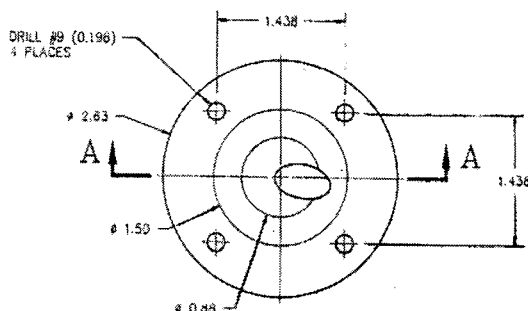


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
CP	CH	D3270	SHEET 2 OF 2
DATE	TITLE		SCALE
05.07.14	FUEL SCUPPER ASSEMBLY		NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23



SECTION A-A



D3270-1 FLAT PATTERN

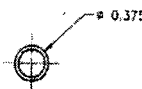


D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT
D3270-1



D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T0.375W.035)

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA SA Date: 15/05/06QA Closed SA Date: 15/05/04

Work Order: <u>130540</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D 3270-1</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4863</u>		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐				2 part moved when were drill		Scrap - destroy	FF MAR 24 2015	DAS 30	DAS 9
Equip/Tooling ☒						no Prod/nc			
Operator ☐									
Material ☐									
Setup ☒	15/03/24	130	2		01/03/24 012-42	\$19.97		15/03/24	15-23-24
Other ☐									
Process ☒									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☒ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other